

Work Order ID 141120

January 27, 2016 10:27:59 AM

141120

No Stock
Please cut Feb 22. Page 1

Item ID: D3608-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Doubler
 Start Date: 1/27/2016 Start Qty: 6.00 ***8* 20 SA** Cust Item ID:
 Required Date: 2/5/2016 Req'd Qty: 6.00 ***8* 20** Customer:
 Reference:

Approvals: Process Plan: SA Date: 1 6 0 1 2 7 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3608	C

100	FLOW WATER JET	0.00							
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100
 Waterjet
 FLOW CNC Waterjet

Memo
 1-Cut as per Dwg D3608
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary

(20) _____ 02/16/24

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110
 QC
 Quality Control

Memo

(20) _____ 02/16/24

120	QC8- Inspect parts - second check	0.00							
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120
 QC
 Quality Control

Memo

(20) _____ 02/16/24

DAS
 38
 9-89
 FEB 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
				OTHER : ☐							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

" Picklist Print

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Work Order ID: 141120

141120

Parent Item: D3608-3

D3608-3

Parent Item Name: Upper Doubler

Start Date: 1/27/2016

Required Date: 2/5/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
 IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
 IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
 Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
 10.11.17 as per PC1 dwg DD verified by:EC IPP Rev:F 10.11.29 as
 per revC dwg DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	224.0000	0.7392	4.668632			

M304S20GA

304/316 .040 Sheet

2/16/02/24

Location

Loc Qty

Loc Code

MAT020

160

m13351

96

m134067

64

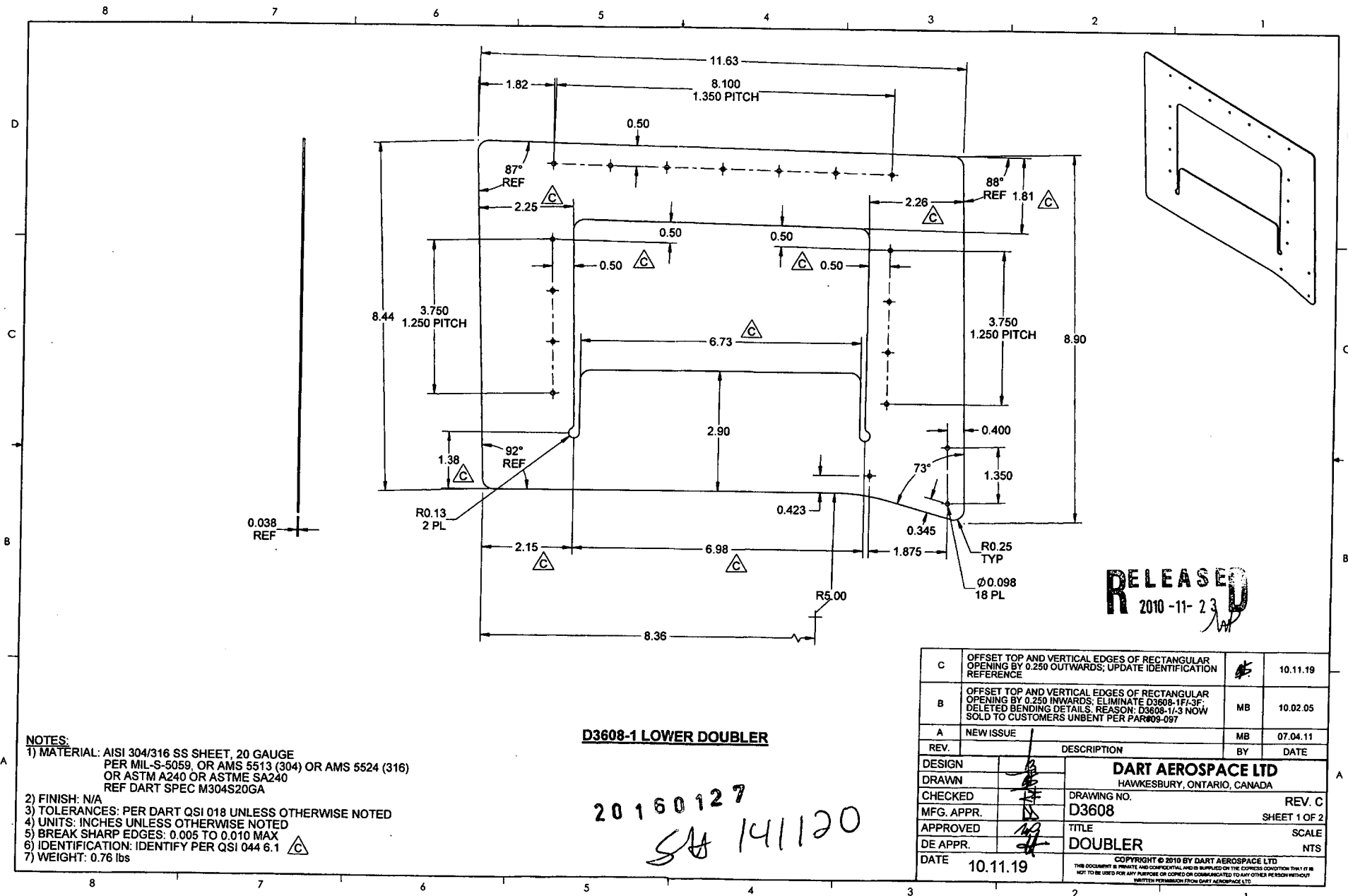
MAT20

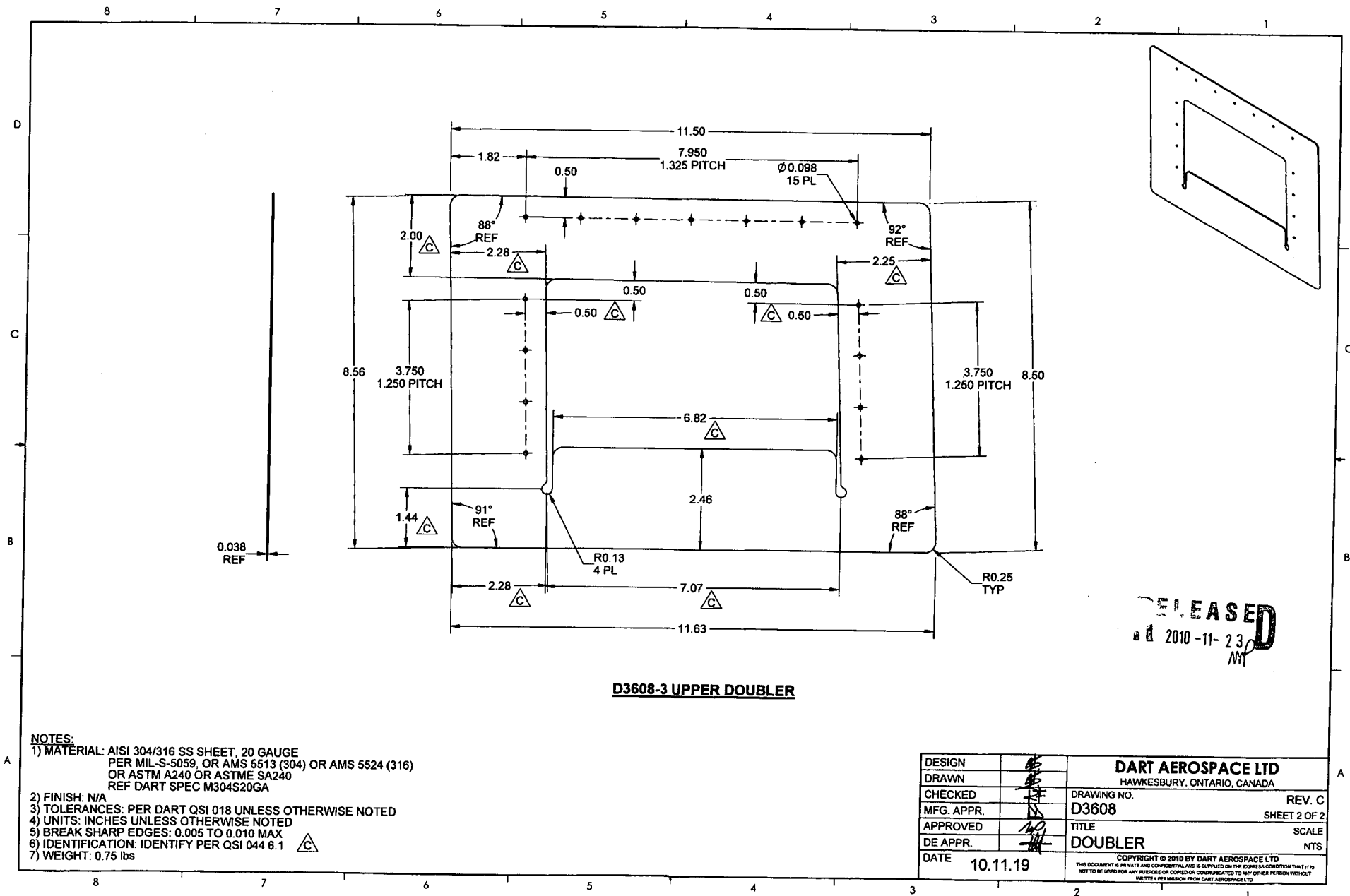
64

m133901

64

15





DART AEROSPACE LTD		Work Order:	141120
Description: Upper Doubler		Part Number:	D3608-3
Inspection Dwg: D3608 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.099	/		V-D-02	
1.82	+/-0.030	1.82	/		V-D-01	
0.50	+/-0.030	.50	/		Tap	
11.50	+/-0.030	11.50	/			
7.950	+/-0.010	7.946	/			
1.325	+/-0.010	1.323	/			
2.25	+/-0.030	2.25	/			
8.50	+/-0.030	8.50	/			
3.750	+/-0.010	3.748	/			
1.250	+/-0.010	1.249	/			
6.82	+/-0.030	6.82	/			
2.46	+/-0.030	2.46	/			
7.07	+/-0.030	7.07	/			
11.63	+/-0.030	11.63	/			
2.28	+/-0.030	2.28	/			
1.44	+/-0.030	1.44	/			
8.56	+/-0.030	8.56	/			
2.00	+/-0.030	2.00	/			
0.040	+/-0.010	.035	/			

Measured by:	D	Audited by:	DAS 33	Preliminary Approval:	
Date:	16/02/24	Date:	FEB 7 4 2016	Date:	

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	10.02.18	Dimensions updated per Dwg Rev B	KJ	
C	10.12.21	Dimensions updated per Dwg Rev C	KJ	